

Claims

[1] An on-line grinding method for a work roll, adapted to press a rotating grinding wheel having elasticity against a work roll of a rolling mill to grind the work roll, characterized in that when a pressing load of the rotating grinding wheel reaches a set load F , which has been set beforehand, after the rotating grinding wheel contacts the work roll,

a forward velocity of the rotating grinding wheel is reduced to decrease an overshoot by which the pressing load of the rotating grinding wheel on the work roll exceeds a set grinding pressing load F_0 .

[2] The on-line grinding method for a work roll according to claim 1, characterized in that the load F which has been set beforehand has a value in a range satisfying the following equation (A):

$$F \leq F_0 - K \times V_1 \times \Delta t \dots \text{ (A)}$$

where

F : set load [N],

F_0 : set grinding pressing load [N],

K : grinding wheel spring rigidity [N/mm],

V_1 : forward velocity [mm/s] of grinding wheel before velocity reduction, and

Δt : control delay time [s].

[3] The on-line grinding method for a work roll according to claim 1 or 2, characterized in that a forward velocity V_2 of the rotating grinding wheel after velocity reduction satisfies the following equation (B):

$$0.6 \times (S \times F_0 / (K \times \Delta t)) \leq V_2 \leq S \times F_0 / (K \times \Delta t) \dots (B)$$

where

V₂: forward velocity [mm/s] of rotating grinding wheel after velocity reduction,

S: ratio of allowable overshoot amount to set grinding pressing load F₀,

K: grinding wheel spring rigidity [N/mm], and

Δt: control delay time [s].